

Split

Work Order ID 53589-2



Page 1

November 9, 2009 11:22:17 AM

Item ID: D3709-1

Accept



Setup Start



Revision ID: A

Item Name: Angle

3

Stop



Start Date: 09/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

09-11-9

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3709

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3709 Dwg Rev: A Prog Rev: A

☐

****grain direction on a 45 degree ****

☐ 2- Deburr if

necessary

1B 9-11-11

6

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1B 9-11-11

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

6

1B 9-11-11

Work Order ID 53589

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Page 2

Item ID: D3709-1

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Setup Start



Revision ID: A

Stop



Item Name: Angle

Start Date: 09/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

80 10/03/09

(3)

Small Fab

Form as per dwg D3709

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

50 10/03/10

(43)

Memo

0.00

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

45 10/03/10

(43) ✓

Memo

0.00

Work Order ID 53589

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Page 3

Item ID: D3709-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Angle

Start Date: 09/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Bl 10-3-10 (3)

170

Identify as per dwg & Stock Location: *83*

0.00



Packaging

Memo

0.00

Packaging

10/3/10 (3)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/11

mf

10-3-11

Picklist Print

November 9, 2009 11:22:21 AM

Page 1

Work Order ID: 53589



Parent Item: D3709-1RevA



Parent Item Name: Angle



Start Date: 09/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No				sf	216.0499	0.5600	3.		
											18 9-11-11	
6061-T6 .063 Sheet												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

216.0499211

110551

32.0341211

112939

184.0158

112939

6

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 53589
B/09-11-9

D3709-3 ANGLE

D3709-1 ANGLE

RELEASED
09/24/97

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3709-X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3709-1 = 0.24 lbs
D3709-3 = 0.16 lbs

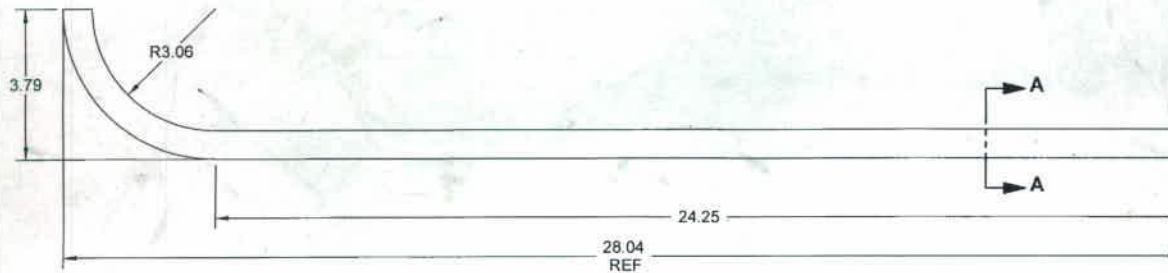
A NEW ISSUE		MB	08.05.02
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.05.02		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

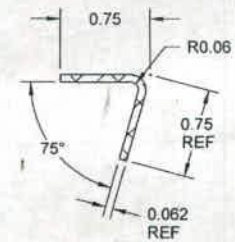
DRAWING NO. **D3709** REV. A
SHEET 1 OF 3

TITLE **ANGLE** SCALE
NTS

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D3709-1 ANGLE
(MAKE FROM D3709-1F)



SECTION A-A
SCALE 2X

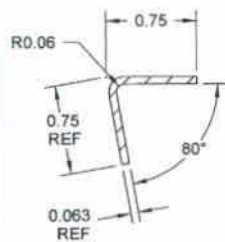


D3709-1F ANGLE FLAT PATTERN

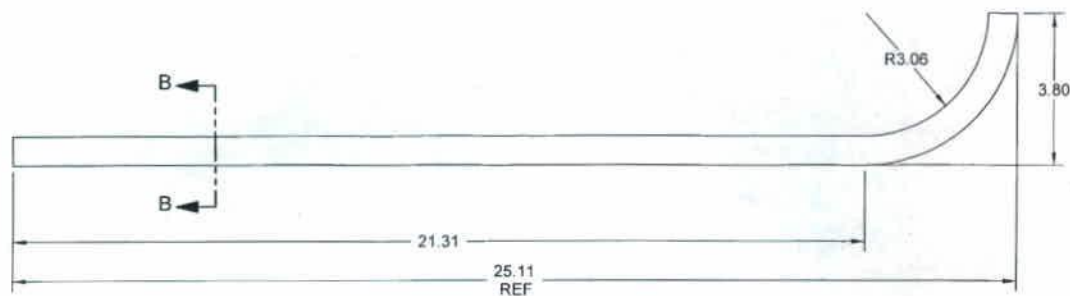
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09/04/09

u/o 53589

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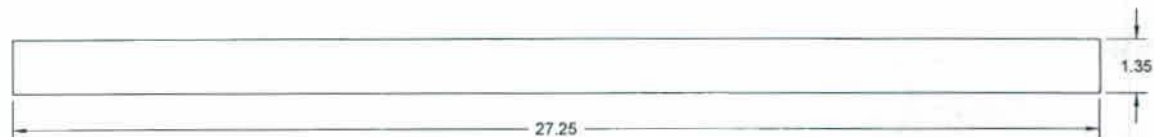


SECTION B-B
SCALE 2X



D3709-3 ANGLE
(MAKE FROM D3709-3F)

GRAIN
DIRECTION



D3709-3F ANGLE FLAT PATTERN

RELEASED
07/04/09

W/0 53589

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